



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5621-042
Job Sheet 198089



Part No: D5621-042

Job Qty: 1 pcs

Part Name: Skylight Window Assembly, RH Clear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/19

Job Tracking No:

Due Date: 9/9/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: D5621 REV.C IPP REV:A 18.05.22 NEW ISSUE DD VERF:JFS IPP REV:B 18.09.04 AS PER DWG REV.B DD VERF:JFS IPP REV:C 19.01.14 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	DAS 13 9-20 70H8044071	1 pcs	9/9/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	1 pcs	9/9/19	9/9/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S217371



Part: D5621-042

Job No: 198089

Serial No/Batch: S217371

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/28/19

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 9	
120 QC 6	1 pcs	9/9/19	0.00 0.00		QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	81
					QC 6 - 81	9-89
130 Packaging 3-1 - Stock - B4B	1 pcs	9/9/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	DAS
					Packaging 3 - 32 - B4B	21
					Packaging 3 - 33 - B4B	9-89
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	9/9/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

OCT 04 2019

OCT 17 2019

OCT 17 2019

Part Op 100 - Issue P/O: _____ Supplier: Llamas Manufacture D5621-042 as per Dwg Notes. C of C is required.
 Descriptions: ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOWS***
 110 - (Receive & Inspect for Damage & Mat'l Certs) C of C is required. ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOWS***
 120 - (QC6- All purchased or subcontracted products) ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOWS***
 130 - (Identify as per dwg & Stock Location: _____) ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE

SURFACE OF THE WINDOWS***

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5621-042P	Skylight Window Assembly, RH Clear	1 Ea (1 ea)	100-Purchasing	S217364

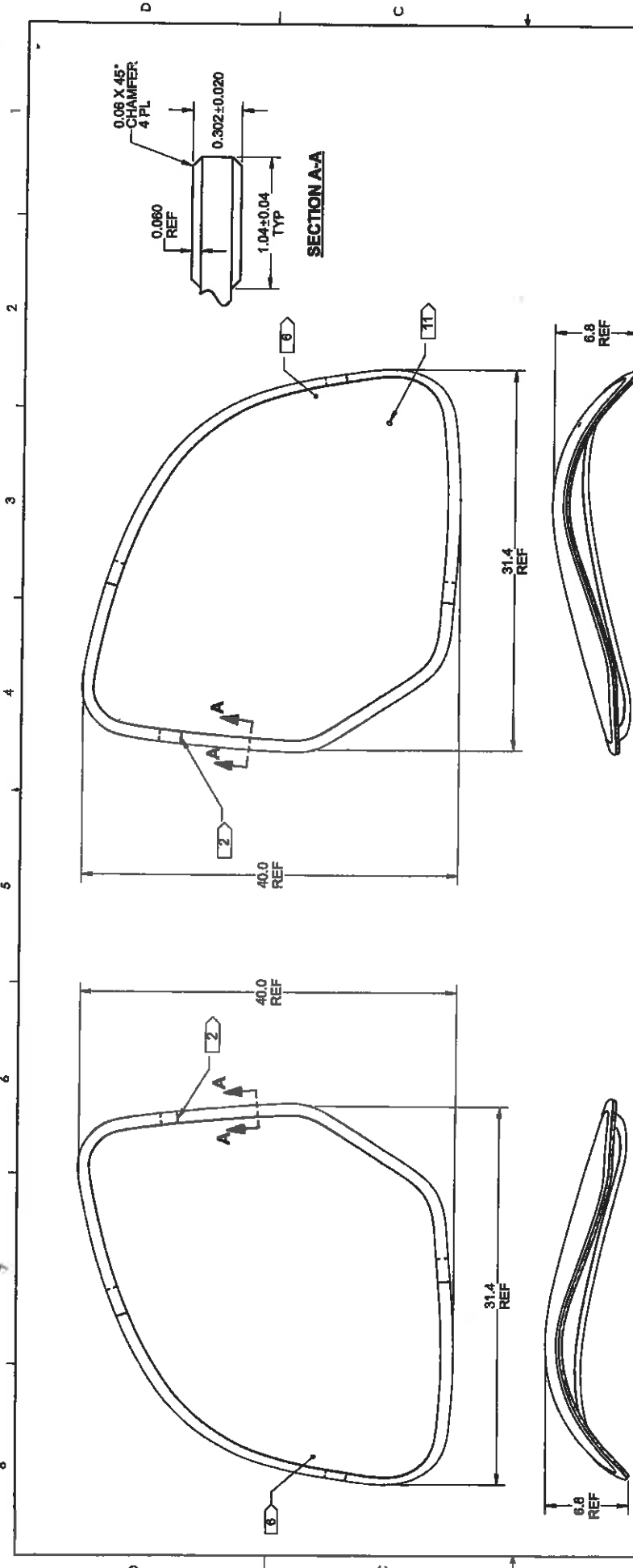
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D5621-042P	1	0	0

Part Specifications

Specifications could not be found.

Plex 7/22/19 11:40 AM Dart.Lavoie.Chantal



D5621-042-044 SKYLIGHT WINDOW, RH

RELEASED
2019 JAN 11
EQU 11-24

D5621-041-043 SKYLIGHT WINDOW, LH

- NOTES:**
- 1) MATERIAL: -041-042: MAKROLON TUFFAK UC/GP, CLEAR, 0.177" THICK
REF DART SPEC MPOLYS.177-01
-043-044: MAKROLON TUFFAK OP, BRONZE #5109, 0.187" THICK
REF DART SPEC MPOLYS.187-02
 - 2) FINISH: APPLY LPI AEROCOAT 107P HARDCOAT (BOTH SIDES)
INSTALL LPI 9149 EDGE ATTACHMENT USING PR1425 PER "D5621-041 CF" (LH) OR "D5621-042 CF" (RH)
IT IS ACCEPTABLE TO SPLICE EDGE ATTACHMENT BETWEEN HOLES.
INNER AND OUTER SPLICES MUST BE AT LEAST ONE HOLE SPACING APART
 - 3) TOLERANCES: PER DART OSI D18 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: ALL TRIMMED SURFACES MUST HAVE FINISH
 - 6) IDENTIFICATION: SANDBLAST IDENTIFICATION USING 0.125" LETTERS IN LOCATION SHOWN (MAX 0.005" DEEP):
D5621-04X (FIN) SN XXX (SIN)
XX-20YY (DATE) 3AL84 (CAGE CODE)
 - 7) WEIGHT: 8.40 - 7.25 LBS
 - 8) FORM PER LPI PROCESS "D5621" USING LPI FORMING TOOL "D5621-041 FM" (LH) OR "D5621-042 FM" (RH) RESPECTIVELY
 - 9) TRIM PER LPI TRIMMING TOOL "D5621-041 TF" (LH) OR "D5621-042 TF" (RH) RESPECTIVELY
 - 10) EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOW
 - 11) DRILL .00.375 HOLE ON -042-044 PER LPI TRIMMING TOOL "D5621-042 TP"
 - 12) ACCEPTANCE CRITERIA:
 - A) MINIMUM THICKNESS AFTER FORMING IS 0.150"
 - B) CONTOUR: MUST FIT FORMING TOOLS WITH A MAX GAP OF 0.060" AT THE TRIM LINE WHEN NO MORE THAN 4X LB WEIGHTS ARE EQUALLY SPACED ON THE PERIMETER
 - C) DISTORTION: INSPECTOR TO VIEW THRU PART. NO MORE THAN 3X 0.060" DEFECTS IN A CIRCLE WITH A 6.77" RADIUS. WINDOW MUST BE GENERALLY PARALLEL EXCEPT FOR WITHIN 1" OF THE WINDOW PERIMETER, WHICH IS NON-OPTICAL

REV.	DESCRIPTION	DATE
C	REVISED NOTE 1	19.01.07
B	ADDED 0.081" AROUND PERIMETER FOR INCREASED EDGE DISTANCE WHEN TRANSFER DRILLING	19.07.25
A	NEW ISSUE	19.02.21
DESIGN	DB	VS
DRAWN	VS	VS
CHECKED	RF	VS
MFG. APPR.	RA	VS
APPROVED	VS	VS
DE APPR.	VS	VS
DATE	19.01.07	

APPROVED

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D5621
REV. C	SHEET 1 OF 1
SCALE	SKYLIGHT WINDOW
NTS	CONFIRMED BY DART AEROSPACE LTD
	THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES FOR WHICH IT WAS ISSUED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044071



Supplier: LLA001-VU
Llamas Plastics Inc.
12970 Bradley Ave.
Sylmar, CA 91342 USA
Phone: 818-362-0371
Fax: 818-362-9780

PO No: POHB044071

PO Date: 7/22/19

Due Date: 9/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Ship To:

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	198077	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed	-	9/10/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
2	198078	D5621-042P			Skylight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed	-	9/10/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
3	198079	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed	-	9/10/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
4	198080	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed	-	9/16/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00



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PURCHASE ORDER

POHB044071



Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
5	198081	D5621-042P			Skyllight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed -		9/16/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
						X1		SEP 19 2019					DP
6	198083	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed -		9/16/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
						X3		SEP 19 2019					DP
7	198088	D5621-041P			Skyllight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed -		9/30/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
						X1		SEP 26 2019					DP
8	198089	D5621-042P			Skyllight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed -		9/30/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
						X1		SEP 26 2019					DP
9	198090	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed -		9/30/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
						X2		SEP 26 2019					DP
10	198174	D5621-041P			Skyllight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed -		10/14/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
11	198175	D5621-042P			Skyllight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed -		10/14/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00



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PURCHASE ORDER

POHB044071



Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
12	198176	D5674-1P			Drill Bit : as per dwg D5674-1 REVA	Firmed	-	10/14/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
Grand Total:													\$17,968.08

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 9/9/19 1:25 PM Dart.Lavoie.Chantal

LLAMAS PLASTICS, INC.

12970 Bradley Avenue
Sylmar, CA 91342-3829

818-362-0371 Fax # 818-362-9780

Packing Slip

Date	Invoice #
9/16/2019	L45306

Bill To

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON, K6A 1K7
CANADA

Ship To

LAVOICE CHANTAL
PHONE: 613-623-5200
EXT. 242
FAX 613-632-1053
CLAVOICE@DARTAERO.COM

P.O. Number		Rep	Via	F.O.B.
POHB044071			CALL FO...	Sylmar, CA
Quantity	Line Item	Description		
1 8		P/N: D5621-042P SKYLIGHT WINDOW ASSY, RH CLEAR REV.C S/N: 008		
1 9		P/N: D5674-1P 5/16" DRILL BIT REV.A		
		COUNTRY OF ORIGIN: USA CURRENCY: US DOLLARS \$		
		RECEIVED SEP 24 2019 DART AEROSPACE LTD.		
		CERTIFICATION OF COMPLIANCE ATTACHED		
		 9/16/19		



LLAMAS PLASTICS INC.

12970 BRADLEY AVE.
SYLMAR, CA 91342
(818) 362-0371
Fax (818) 362-9780

DATE: 9/16/19

CERTIFICATION OF COMPLIANCE

TO: **Dart Aerospace**

RE: Contract/Purchase Order No (s): **POHB044071**

Line Item #: **8 & 9**

Shipper No(s): **L45306**

Part No(s): **D5621-042P SKYLIGHT WINDOW ASSY, RH CLEAR**
REV.C D5674-1P 5/16" DRILL BIT
REV.A

Quantity: **1 EA.**

Serial No (S): **008**

Lot/Batch # (when applicable): **N/A**

DAS
81
9-89

This is to certify that the material and/or processes used to fabricate the above part number, comply with the specifications, drawings and other requirements of the contract or purchase order indicated.

The required reports and other certificates covering all material in the parts listed above, are on file and available for examination upon request.

Llamas Plastics, Inc.

Quality Rep